

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007309**Date Inspected:** 18-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

<b>CWI Name:</b>	Pin-Tang Hsu		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	Tower, Jacking and Deviation Saddles	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date, 6/18/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and the associated built up plate sections in the Fabrication shop #4 and at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

**WEST DEVIATION SADDLES**

W2E1 - Assembled saddle is idle in Fabrication Shop #4.

W2E2 - Scheduled Wet MT 10% verification inspection was postponed by JSW personnel to allow time for their staff to conduct an inspection of the machined surfaces this weekend it has been asked that this QA Inspector delay his inspection until next week (week of 21 ~ 27 June 2009) per JSW representative Mr. Hideaki Kon.

W2W2 - Cast section is now in Fabrication Shop #4. Built up plate portion located adjacent its mating cast section is having bevels ground by hand grinding at areas on plate ribs to mate with stem radius. The process continued through QA Inspector's shift by JSW welder Mr. Y.Ohta.

W2W3 - Saddle Casting is located in No. 2 Machine shop. Built up section undergoing contour grinding of cope holes and touch up welding to end runs at cope by welder T.Kawakami 08-5079 by procedure SJ-3011-3 using FCAW, 1.6mm TM95 consumable weld wire in Fabrication Shop #4.

**TOWER SADDLES**

T1-2 - While located in Fabrication Shop #4, base plate CJP welds' UT indications are still under review for

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## WELDING INSPECTION REPORT

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completeness for reporting by QA NIS technician, M.Sato #81.

T1-3 - Observations by QA Inspector were as follows: earlier welds identified by NIS MT Technicians, have been ground at sites identified as indications or conditions requiring grinding. Report expected to follow from NIS technicians of this NDE inspection. These observations were made in the Fabrication Shop #4.

### EAST SADDLES

E2E1 - As relayed to this QA Inspector by JSW representative Mr. Hideaki Kon, an ECS is being prepared identifying repairs and their classification. Repairs will be conducted in its current location, in Foundry.

E2W1 - Welders, Y.Kabutomori 06-8000 is continuing weld of large Major repair area identified as 4-2 in ECS ABF-SUB-000643R14 per procedure SJ-3026-4, using SMAW process and 5mm E9016 electrode. The process in the Foundry of repairing the excavation is being monitored by JSW Weld Engineer Mr. T.Imai. In Fabrication Shop #4, the Splay Plate Cover is having the last of the plates 24-5 welded by Y.Watanabe 73-3873 and J. Yaegashi 07-2941, they have resumed following two other welders that have welded its second side since back gouge MT by M.Sato #81. The current welders are being monitored randomly by QC CWI Mr. Pin-Tang Hsu.

West Jacking Saddle - Cast Section now undergoes carbon arc shaping to the second side of the casting in the Foundry by one individual. The observances continued through to 18:00 local time.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

### Summary of Conversations:

No significant conversations to report on this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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